







Date: Friday, 28/09/2007 2:56:40 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3245-1 PREL
Job Number : 34907	
Estimate Number : 10804	
P.O. Number : <i>N/A</i>	Part Number : D3245041
This Issue : 28/09/2007 S.O. No. : <i>N/A</i>	Drawing Number : ECN 1040P
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : 28/09/2007 Type : SMALL /MED FAB	Drawing Revision : <i>N/A</i>
Previous Run : 00015	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 05/10/2007 Qty: 2 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment :	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304S22GA 304/316 .032 Sheet
	
Comment: Qty.: 0.8442 sf(s)/Unit Total : 1.6884 sf(s) 304/316 .032 Sheet Batch: <i>M105262</i> <i>IB 07-10-1</i>	
2.0	WATER JET FLOW WATER JET
	
Comment: FLOW WATER JET 1-Cut as per Dwg D3245 ****prog.D3245-1/-2**** Dwg Rev B per ECN 1040P Prog Rev: <i>PREL</i> <i>IB 07-10-1</i> 2-Deburr if necessary <i>IB 07-10-1</i>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>IB 07-10-1</i>	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <b>ENGINEERING APPROVAL</b> <i>[Signature]</i> <i>602 p.01</i>	
5.0	BRAKE NC NC BRAKE
	
Comment: NC BRAKE Deburr if necessary C'sink as per Dwg D3245 Form D3245-1 as per Dwg D3245 Identify as D3245-1 <i>mf 07-10-02</i>	

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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3245-1 PREL

Job Number: 34907

Part Number: D3245041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*mf 07/10/03*

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
ASSEMBLE PER DRWG

*mf 07-10-03 (2)*

8.0	235018C3Y	RIGID RECEPTACLE
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)  
RIGID RECEPTACLE

*m105784 x 1mx, m105729 x 15mx.*

*mf*

9.0	MS20427M33	Rivet
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)  
Rivet

*m102328.*

*mf 07-10-03*

*(PFD) Last Page*

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*07/10/04 302.0.04*

*mf*

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*07/10/04 (2)*

12.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*(2) 07/10/04*

Job Completion



POSITIVE RECALL

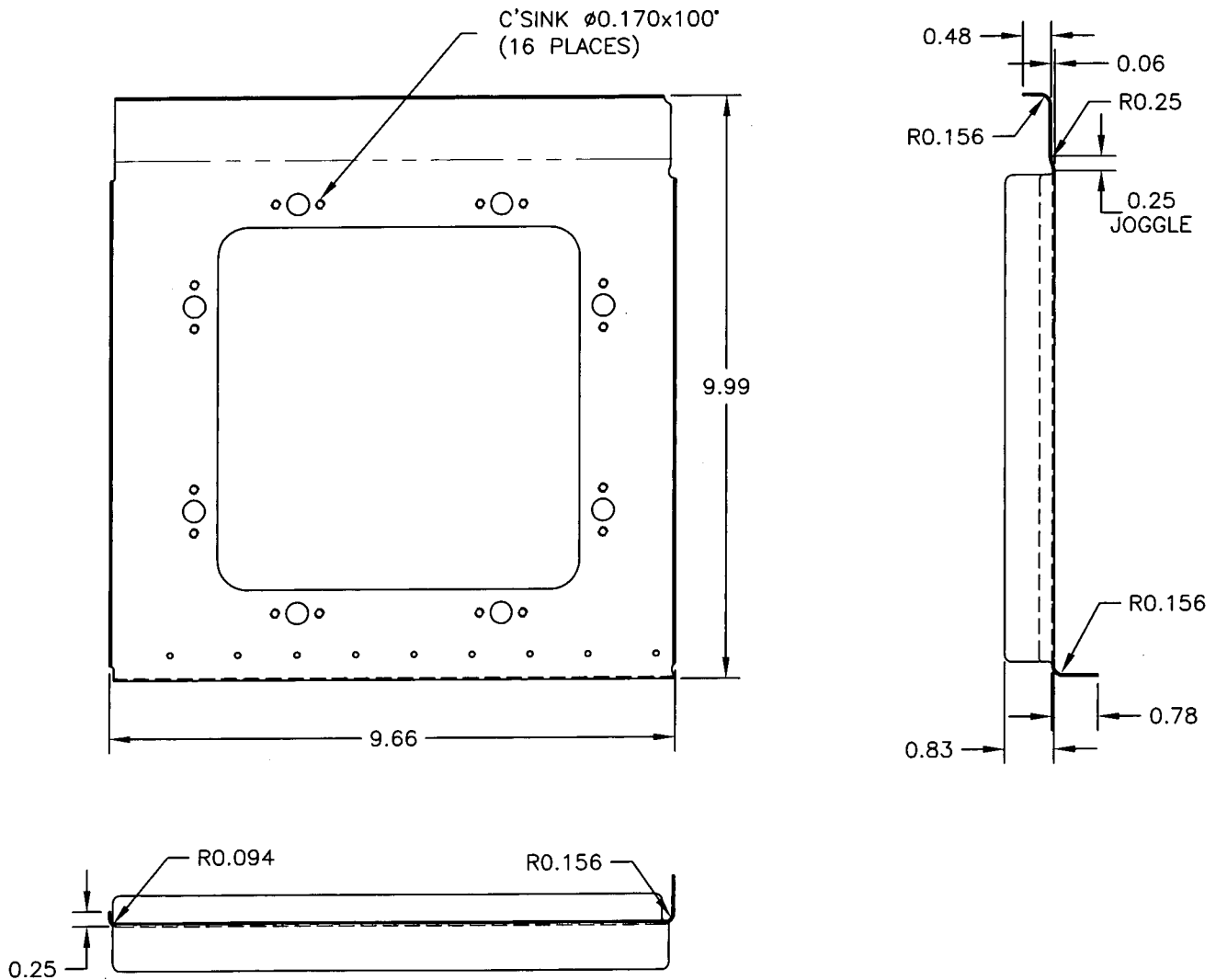
EFFECTIVE *07/10/03* AUTH *4*

RELEASED *02/10/04* DATE *3*

**PRELIMINARY ISSUE**

07.09.26

DESIGN RF	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3245	REV. B SHEET 3 OF 6
DATE 07.09.26	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:3



**D3245-1 PANEL BEND DETAIL SHOWN  
BEND D3245-2 PANEL OPPOSITE**

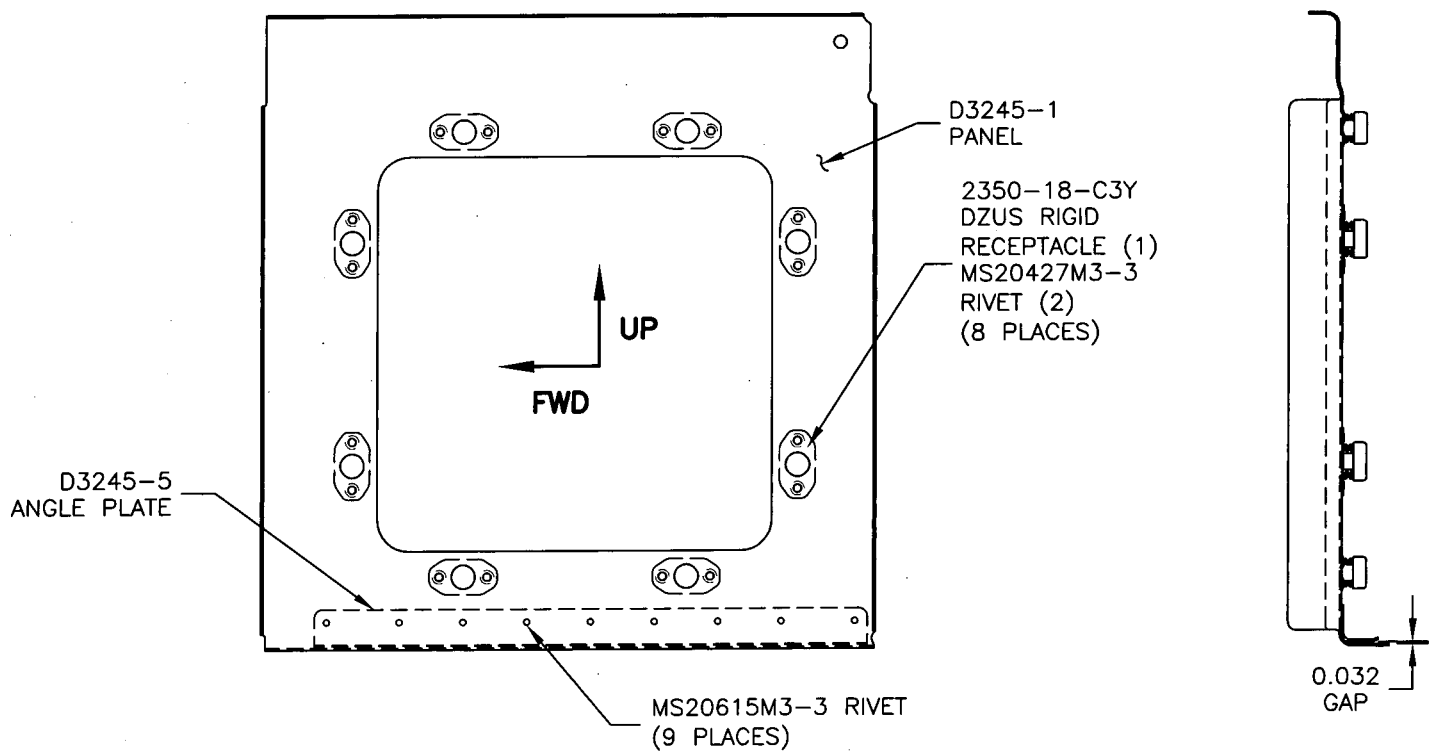
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**PRELIMINARY ISSUE**

07.09.26

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3245	REV. B SHEET 1 OF 6
DATE 07.09.26		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:3
A	04.01.27	NEW ISSUE	
B	07.09.26	INSTALL HOLES/NUTPLATES ARE IN IINs	



**D3245-041 ACCESS PANEL ASSEMBLY**

**D3245-041 NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 5) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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DART AEROSPACE LTD		Work Order:	34907
Description: ACCESS PAWE ASSEMBLY		Part Number:	D3245-1
Inspection Dwg: D3245-1 Rev: PREL		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .375	+ .006 - .001	.374				
Ø .098	+ .004 - .001	.99				
9.400	+/- .010	9.400	*			
1.350	+/- .010	1.350	*			
.100	+/- .010	.105	*			
11.040	+/- .010	11.040	*			
8.350	+/- .010	8.350	*			
.930	+/- .010	.931	*			
10.565	+/- .010	10.565	*			
6.000	+/- .010	6.000	*			
.812	+/- .010	.814	*			
.233	+/- .010	.233	*			
1.150	+/- .010	1.150	*			
.253	+/- .010	.252	*			
2.020	+/- .010	2.024	*			
2.230	+/- .010	2.232	*			
6.200	+/- .010	6.202	*			
.375	+/- .010	.375	*			
.400	+/- .010	.400	*			
3.500	+/- .010	3.500	*			
R .125	+/- .010	.125	*			
R .13	+/- .030	.13	*			
R .50	+/- .030	.50	*			

Measured by:	HB
Date:	07-10-1

Audited by:	En
Date:	07/10/01

Prototype Approval:	
Date:	07/10/01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/03	9.1	ADD step for installing D3245-5 (Angle Plate)	W	07/10/03			En 07/10/03
07/10/03	7	D3245-5 (1) BATCH # <u>B 3407</u> MS 206 15 m3-3 Rivet (19) BATCH # <u>M17654x3mx</u> , <u>M18235x</u> <u>16mx</u>	MF	07/10/04	Z		En 07/10/04

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries